

Date: Tuesday, 07/04/2009 10:28:11 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD ASSEMBLY RH/ DSI 9335
Job Number	: 47002		
Estimate Number	: 12779		
P.O. Number	:	Part Number	: D350600242
This Issue	: 07/04/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: IIN REV.C PG11,18-21
First Issue	: / /	Project Number	: N/A
Previous Run	: 46180	Drawing Revision	: C
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 10/05/2009
Checked & Approved By	: <u>JUD 09.04.07</u>	Qty:	1 Um: Each
Comment	: Est Rev:A 07.03.07 new issue EC est rev B 07.04.16 reformat, D3188 rev.E EC Est Rev:C 08-09-30 add primer in step 44 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Handwritten: JUD CL 09/06/17



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-242 CHG001

Handwritten: 09/06/17

2.0	47002A	SPACEPOD BODY RH
-----	--------	------------------



Comment: Sub-Component SPACEPOD BODY RH

1 x D3188-2M Batch 45700 A

Handwritten: 090617

3.0	47002B	SPACEPOD DOOR RH
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Comment: Sub-Component SPACEPOD DOOR RH

1 x D3186-4 Batch 45695

Handwritten: 090615

4.0	D31872 N/A	Spacepod Floor
-----	-----------------------	----------------



Handwritten: D3798-042

Handwritten: BJA 09/06/17
45579



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 ~~D3187-2~~ Floor ~~31886~~

Handwritten: 090616

5.0	ALS41032130	Insert
-----	-------------	--------



Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s)

insert

batch: M110511

Handwritten: 09/09/15 (XU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:28:11 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 47002

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

A3235020935

Washer - Countersunk



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Washer - Countersunk

104156

SS 07/06/15 (X)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Drill holes in D3188-2 using drill jig DT8971
2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188
3-Deburr
4-Install inserts in D3188-2 as per Dwg D3188.

090616

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

D2986

Black Neoprene Foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)
neoprene foam
batch:

N/A

From R/O

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

N/A

Remove Estimate

11.0

D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lock Nut
batch:

48238

SS 07/06/15 (X)

12.0

D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BALL STUD

37674

SS 07/06/15 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.06.17	9210	Remove Steps 9210 Permanent Change	HJ	09/06/17		<i>[Signature]</i> 09/06/17	<i>[Signature]</i> 09.06.17

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:28:11 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 47002

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

BATCH:

M111279

8809100/15 (X)

14.0

D35672

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch:

339678

Location (A ?)

88090616

15.0

D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch:

46162

8809100/17 (X)

16.0

MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Batch:

4007

PTD →

17.0

D35381

Hinge Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HINGE BRACKET

batch:

44650

8809100/17 (X)

18.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch:

35432

8809100/17 (X)

19.0

AN526C832R24

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch:

M104603

8809100/17 (X)

W/O: 47002 EST: 12779

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-600-242 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
090616	16	MS20426 AD45 are too long	<i>[Signature]</i> 090616	Replace with MS20426 AD44 M15541	<i>[Signature]</i> 090616	<i>[Signature]</i> 09.06.17	<i>[Signature]</i> 090617	<i>[Signature]</i> 09.06.17
				Permanent Change	<i>[Signature]</i>	09/06/17		

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:28:11 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 47002

Part Number: D350600242

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	AN960JD8	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M116917

SS 09/06/17 (X)

21.0	MS21042L08	Nut
------	------------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: M111889

SS 09/06/17 (X)

22.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

****This step separates hardware, previous steps is for body & floor****

090616

23.0	MS270390811	Screw
------	-------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M108335

SS 09/06/17 (X)

24.0	AN960JD8	Washer
------	----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M116917

SS 09/06/17 (X)

25.0	NAS1515H3	Washer
------	-----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M116397

SS 09/06/17 (X)

26.0	MS21042L08	Nut
------	------------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M111889

SS 09/06/17 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:28:11 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 47002

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total: 11.3400 f(s)

3/4 Seal

Cut 127.00" long batch: 48173

JS 09/06/17 (X)

28.0

D35672

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

DECAL

batch: B39678 Location CA?

~~JS~~ 09/06/17

29.0

D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Door Latch

batch: 45554

JS 09/06/17 (X)

30.0

D2585

Mounting Channel



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Latch Clamp

batch: 45815

JS 09/06/17 (X)

31.0

D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Latch Plate

batch: 41178

JS 09/06/17 (X)

32.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Screw

batch: M110915

JS 09/06/17 (X)

33.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

batch: M111279

JS 09/06/17 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:28:11 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 47002

Part Number: D350600242

Job Number:



Seq. #:	Machine Or Operation:	Description :
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34.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
batch: 111274

35.0	D28571	Hinge Bracket
------	--------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Hinge Bracket
batch: 45788

36.0	D28572	Hinge Bracket
------	--------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Hinge Bracket
batch: 43363

37.0	D2228	Bracket Plate
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Backing Plate
batch: 30679

38.0	AN526C832R10	Screw
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Screw
batch: M164603

39.0	AN960JD8	Washer
------	----------	--------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Washer
batch: M116917

40.0	MS21042L08	Nut
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Nut
batch: M11889



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:28:11 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 47002

Part Number: D350600242

Job Number:



Seq. #:	Machine Or Operation:	Description :
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41.0	D35571	Bracket
------	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BRACKET
batch: 32647

8809/06/17

42.0	AN526C832R14	Screw
------	--------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Screw
batch: M10496

PTO →

43.0	AN526C832R10	Screw
------	--------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Screw
batch: M104603

8809/06/17

44.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble D3186-4 door with D3188-2 body as per Dwg ICA-D350-600
Hardware on previous steps is for door ass'y*

1-Drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled fibres 10% to weight.
A/R Hysol batch: M110970 expire date: Dec 4 2009
A/R Milled fibres batch: M100859

2- Prime (grey) as necessary per QSI005
Primer batch: M112062
Hardner batch: M112062

3-Attach Neoprene Foam to floor using Contact Cement
A/R Contact Cement Batch: N/A

AD 090616

45.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
------	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8809.06.17


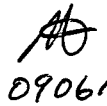



W/O: 47002 EST: 12779

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-600-242 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
090616	42	AN526C832R10 IS TOO LONG		Replace with AN 526C832 R10	 090616	 090607	 090612	 090617

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:28:12 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 47002

Part Number: D350600242

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

46.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

09.06.17

47.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 44

Batch: m111013

09/06/17

48.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
------	-----	---



Comment: Inspect Wing Walk

09-06-17

49.0	K10021	Spacepod Hardware Kit (-241)
------	--------	------------------------------



Comment: Qty.: 1.0000 (s)/Unit Total: 1.0000 (s) B 48266

09/06/17

50.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

09/06/17

51.0	D350600449	Switch Relocation
------	------------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
SWITCH RELOCATION KIT B47203

09/06/17

52.0	D2985	Label
------	-------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Label

batch: B41341

09/06/17

53.0	D35471	Bracket
------	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BRACKET

batch: 35455

09/06/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:28:12 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 47002

Part Number: D350600242

Job Number:



Seq. #:	Machine Or Operation:	Description :
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54.0	D35501	Strut
------	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STRUT

batch: B36226

55.0	D35527	Door Prop
------	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CARBON STEEL GAS SPRING

batch: B32644

56.0	D35547	Ball Stud
------	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: 37674

57.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M111279

58.0	D30153	Locknut
------	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: 48238

59.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

60.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location:

PPP Rev:

B

9/4/17

SL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 47002

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

61.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/17 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

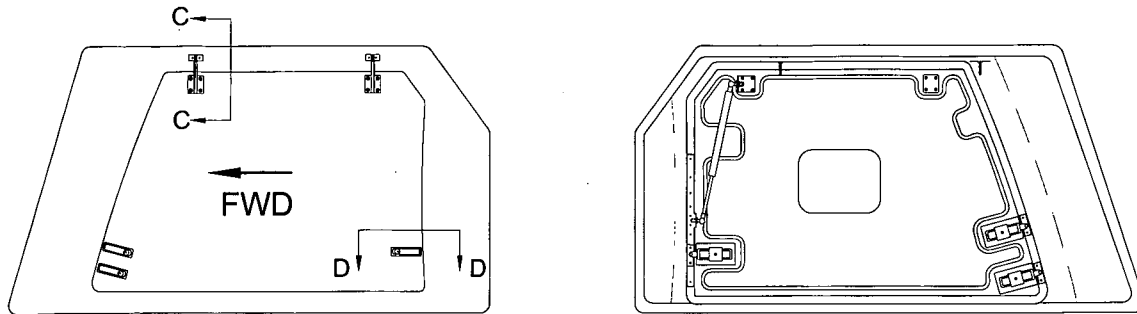


FIGURE 6(a). -141 SPACEPOD KIT (-142 OPPOSITE, -143 SIMILAR)
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)

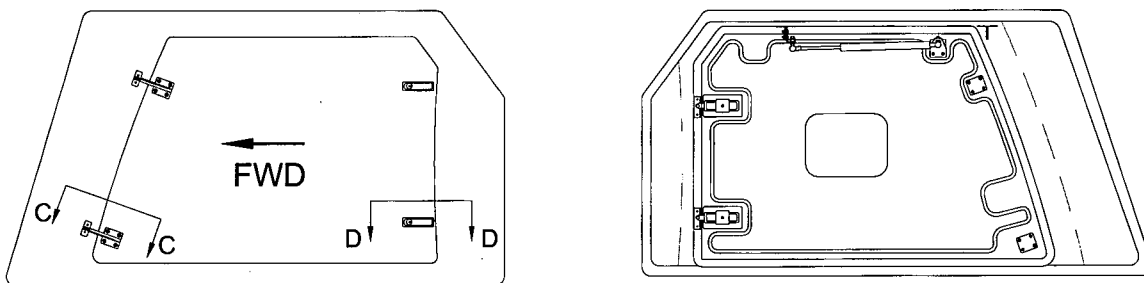
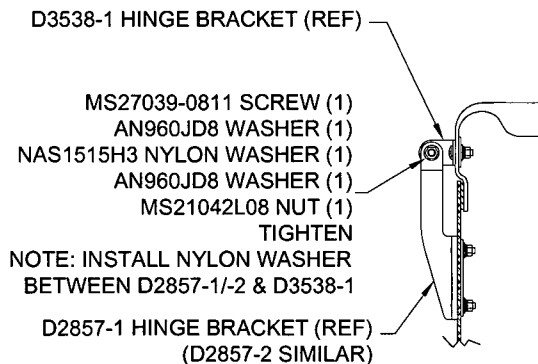
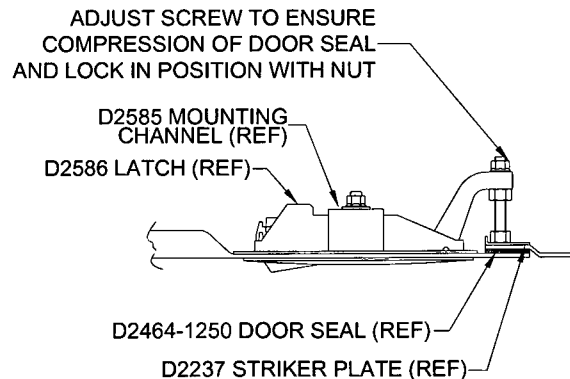


FIGURE 6(b). -241 SPACEPOD KITS (-242 OPPOSITE, -243 SIMILAR)
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



SECTION 'C-C' HINGE

(-141 SHOWN; -142/-143/-241/-242/-243 SIMILAR)



SECTION 'D-D' LATCH

SHOP COPY

RETURN TO

FACTORY

ENGINEERING

DESIGN

SECTION

WITHOUT NOTICE

NO. 47002

3.2.12 Re-install the following components that were removed from the aircraft in earlier steps:

- Re-install the battery shelf cover or wiring cover per the Aircraft Maintenance Manual. If it is necessary to trim the lower edge to clear the pod floor, touch up the paint using MIL-C-85285 polyurethane paint.
- If applicable, re-install the pop-out float cylinders per the Aircraft Maintenance Manual.
- Re-install the belly panel per the Aircraft Maintenance Manual.

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Revision: C

Date: 07.02.20

- 3.4.5 After the paint has dried, apply the D2464-1250 neoprene seal where removed in earlier steps.
- 3.4.6 Cut out the rectangular section shown in Figures 14(a) and 14(b). Install the D2586 latch, D2588 mounting channel and D2621 latch plate that were removed earlier from the door using new hardware as shown in Figure 14(c).

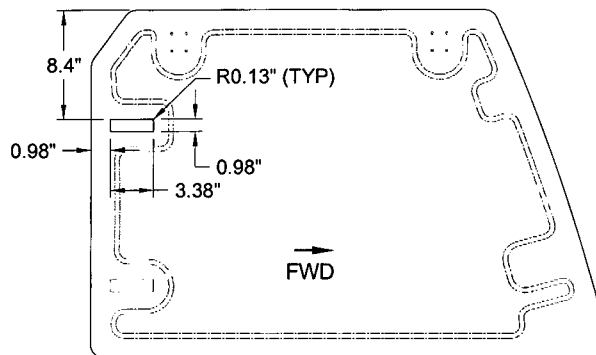


FIGURE 14(a). D3186-1 SPACEPOD DOOR LATCH CUTOUT
(APPLICABLE FOR -041/-043/-141/-143 KITS)

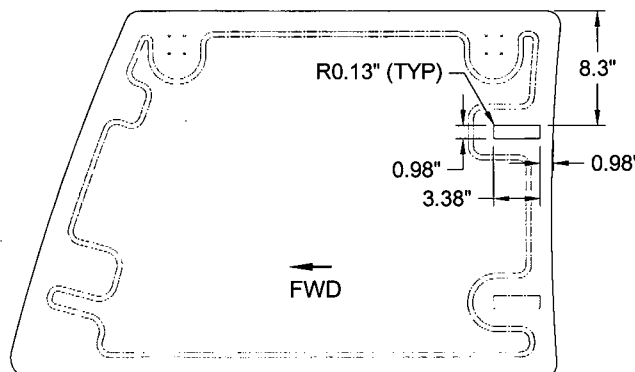


FIGURE 14(b). D3186-2 SPACEPOD DOOR LATCH CUTOUT
(APPLICABLE FOR -042/-142 KITS)

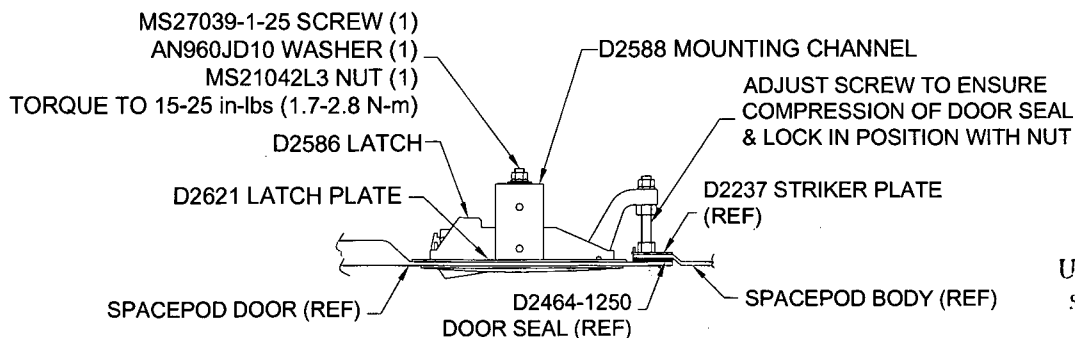


FIGURE 14(c). LATCH INSTALLATION
(SHOWN WITH DOOR INSTALLED ON POD)

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- 3.4.7 Position the D2857-1/-2 hinge brackets as shown in Figure 15(a) for the LH side and Figure 15(b) for the RH side. Transfer drill the $\varnothing 0.172$ " mounting holes on each bracket to the **Spacepod™** door. Install the hinge brackets as shown in Section J-J.

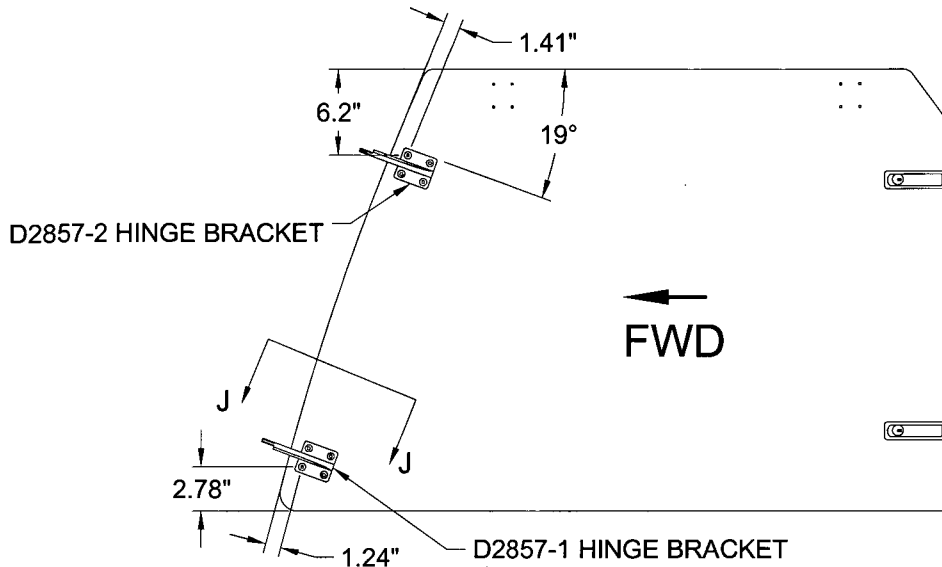


FIGURE 15(a). HINGE BRACKET POSITION ON LH D3186-1 SPACEPOD DOOR

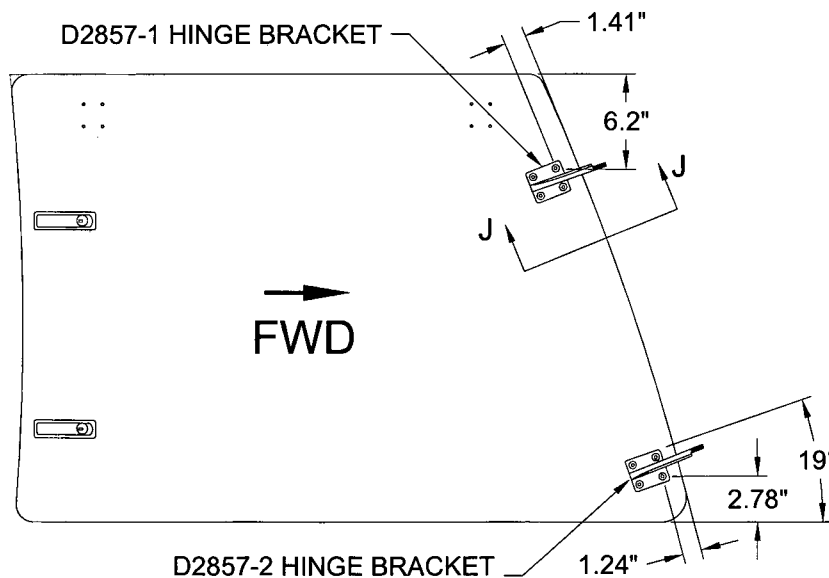
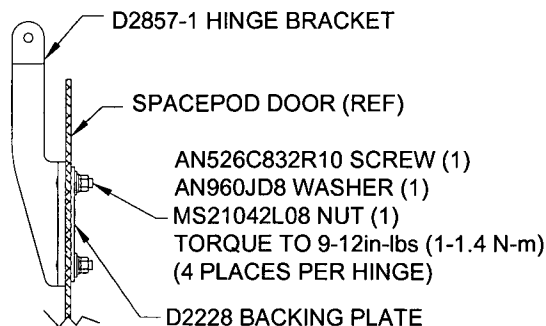


FIGURE 15(b). HINGE BRACKET POSITION ON RH D3186-2 SPACEPOD DOOR

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SECTION 'J-J' HINGE BRACKET INSTALLATION
(D2857-1 SHOWN; D2857-2 SIMILAR)

- 3.4.8 Install the D3557-1 bracket in the existing forward hinge mounting holes with the D2228 backing plates and the D3554-7 ball stud as shown in Figure 16.

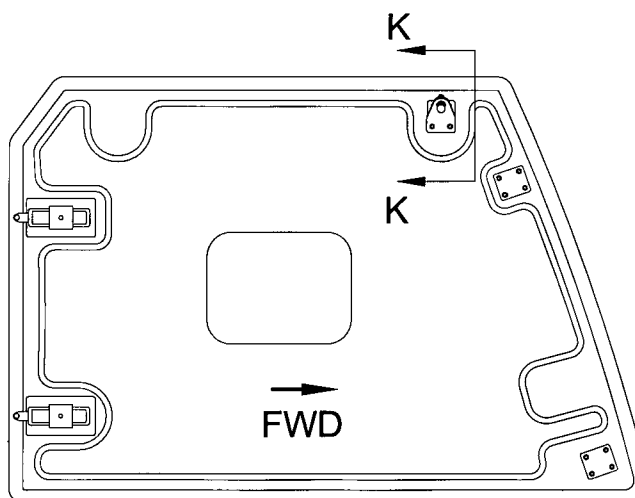
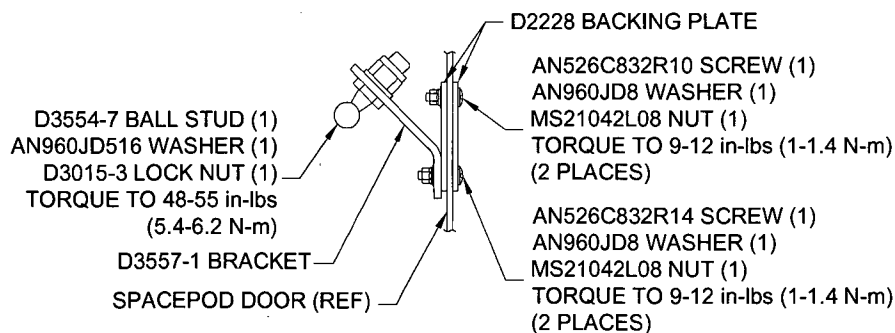


FIGURE 16. BRACKET AND BALL STUD INSTALLATION ON SPACEPOD DOOR
(INSIDE OF D3186-1 SHOWN; D3186-2 OPPOSITE)



SECTION 'K-K'

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Date: 07.02.20

- 3.4.9 Install the hinge brackets on the pod as shown in Figures 17(a) and 17(b):
- Assemble the D3538-1 hinge brackets with the D2857-1/-2 hinge brackets as shown in Figure 17(b). Position the door on the pod and transfer mark the mounting holes from the D3538-1 hinge brackets to the **Spacepod™** body.
 - Remove the door and drill Ø0.375" holes where marked. Remove the foam inner layer 0.250" around the hole between the inner and outer skins as shown in Figure 17(a).
 - Apply tape or an equivalent backer to the inner side of the holes to prevent epoxy filler from going through. Fill the cavity between the skins completely with Hysol 934NA mixed with milled glass fibers to in a ratio of 10:1 or Metalset A4. Allow the material to cure.
 - Reposition the **Spacepod™** door and hinges and transfer drill the Ø0.172" D3538-1 hinge bracket mounting holes to the pod.
 - Install the hinge brackets and **Spacepod™** door as shown in Figure 17(b).

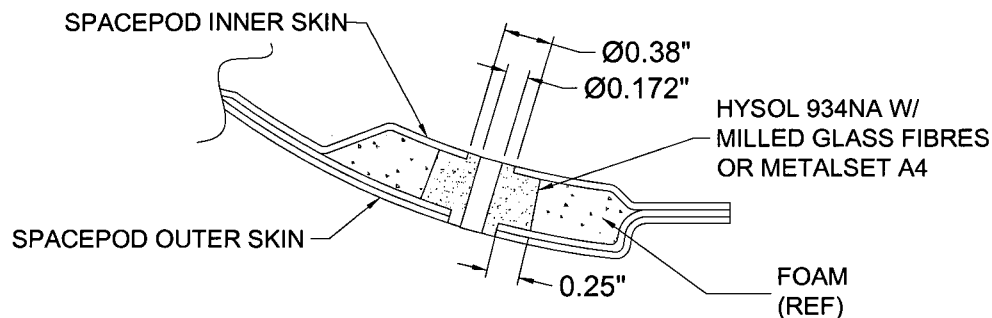


FIGURE 17(a). COMPOSITE MODIFICATION

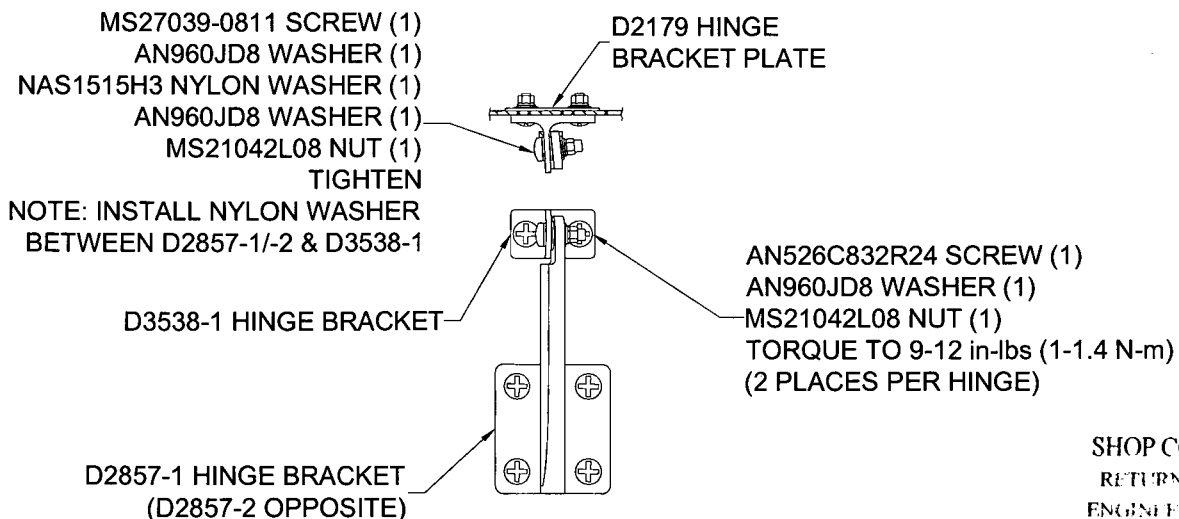


FIGURE 17(b). HINGE BRACKET INSTALLATION
(D2857-1 SHOWN; D2857-2 OPPOSITE)

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